



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3179-041
Job Sheet 196648



Part No: D3179-041

Job Qty: 10 pcs

Part Name: Litter Tie Down (Non-Locking)

4 pcs.

DAS
21
9-89



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/12/19

Type: Stock

July 18
5010

Created By: Marie Lajeunesse

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

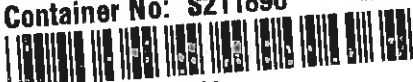
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		7/12/19	0.00	0.83	Bandsaw - 1		
110	HAAS 4 Axis - B4B	10 pcs		7/12/19	0.37	18.18	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		7/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Container No: S211896



Part: D3179-041

Job No: 196648

Serial No/Batch: S211896

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/05/19

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				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	10	7/12/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
140	Handfinish - 1-1 Chemical-B4B	10	7/12/19	0.00 0.81	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B

19-09-09

SEP 09 2019

						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	10 pcs	7/12/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	BL 19-9-9.
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
160	Powdercoat - 1 White GI(A)- B4B	10 pcs	7/12/19	0.00	0.60	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-9-9.
						Powdercoat - 4 - B4B	
170	QC 3	10 pcs	7/12/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	

						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	SMB 19/09/19
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
180 Small Fab - 2 - B4B	10 pcs	7/12/19	0.00	1.49		Small Fab - 1 - B4B	DAS 58 9-89 SEP 10 2019
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
190 QC 5	10 pcs	7/12/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	SEP 10 2019 DAS 40 9-89
200 Packaging 3-1 - Stock - B4B	10 pcs	7/12/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS 28 9-89
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	10 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 100 - (Bandsaw) Cut blanks: 12.150" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA297 Rev: E & Dwg D3179-1 Rev: E
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Small Fab) Assemble as per Dwg D3179
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	10.1250 ft (1.0125 ea)	100-Bandsaw - 1	5158318
D2372 6A117	Quick Release	20 pcs (2 ea)	180-Small Fab - 2 - B4B	5201843 x 4
D2444 6A127	Pip Pin Assembly	10 pcs (1 ea)	180-Small Fab - 2 - B4B	5197825
MS21042L3	Nut	4-10 Ea (1 ea)	180-Small Fab - 2 - B4B	5204283
MS27039-1-13	Screw	4-10 Ea (1 ea)	180-Small Fab - 2 - B4B	5071833
NAS1149D0332J	Washer	12-30 Ea (3 ea)	180-Small Fab - 2 - B4B	5209100

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	10	19	0
180-Small Fab - 2 - B4B	D2372	20	8	0
	D2444	10	0	0
	MS21042L3	10	1,419	0
	MS27039-1-13	10	370	0
	NAS1149D0332J	30	3,102	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 196648
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	0.997	✓		Vern.	
R0.40	+/-0.030	0.400	✓		Machine	
R0.38	+/-0.030	0.375	✓		R.G.	
1.70	+/-0.030	1.695	✓		H.G.	
Ø0.191	+0.005/-0.001	0.191	✓		G.P.	
10.500	+/-0.010	10.500	✓		H.G.	
4.250	+/-0.010	4.250	✓		H.G.	
Ø0.246	+0.005/-0.001	0.246	✓		G.P.	
1.50	+/-0.030	1.497	✓		Vern.	
0.750	+/-0.010	0.746	✓		Vern.	
1.000	+/-0.010	0.992	✓		Vern.	
4.00	+/-0.030	3.992	✓		Vern.	
1.00	+/-0.030	1.002	✓		Vern.	
1.38	+/-0.030	1.400	✓		Vern.	
1.875	+/-0.010	1.8815	✓		H.G.	
2.125	+/-0.010	2.130	✓		H.G.	
2.88	+/-0.030	2.885	✓		H.G.	
3.31	+/-0.030	3.310	✓		H.G.	
R0.375	+/-0.010	0.375	✓		R.G.	
R0.50	+/-0.030	0.500	✓		Machine	
Ø0.191	+0.005/-0.001	0.191	✓		G.P.	
R0.25	+/-0.030	0.250	✓		E.M.	
R0.375	+/-0.010	0.375	✓		R.G.	
R0.38	+/-0.030	0.375	✓		R.G.	
12.00	+/-0.030	12.000	✓		H.G.	
9.000	+/-0.010	9.000	✓		H.G.	
7.50	+/-0.030	7.500	✓		H.G.	
4.50	+/-0.030	4.500	✓		H.G.	
2.88	+/-0.030	2.880	✓		H.G.	
2.250	+/-0.010	2.250	✓		H.G.	
1.000	+/-0.010	1.000	✓		H.G.	
0.50	+/-0.030	0.498	✓		Vern.	

Measured by: 73 9-89	Checked by: 20 9-89	QC Inspector:
Date: 19-09-04	Date: 19-09-09	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____		DISPOSITION		DEPARTMENT/PROCESS				MRB (QSI042)			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____		Sequence #: _____		QTY Affected: _____							
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Completed By _____							
				Lead hand / Supervisor _____							
				QC / QA Coordinator _____							